DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-020272
Date Inspected: 01-Feb-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC)

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	N/A			**CWI Present:**	☐ Yes	☑ No	
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 12AE to Segment 12BE (Transverse Splice T-Ribs)

This QA Inspector performed Dimension Control Inspection on the Transverse Splice T-Ribs to T-Ribs for the Segment 12AE to Segment 12BE between Panel Point (PP) 112.5 to PP 113 at the following locations at OBG Trial Assembly:

Work Point E1 towards Work Point E3 (Side Panel Bike Path Side) total 19 T-Ribs.

Work Point E3 towards Work Point E4 (Bottom Panel) total 18 T-Ribs.

Work Point E4 towards Work Point E6 (Side Panel Cross Beam Side) total 19 T-Ribs.

The QA Inspector measured the Vertical Offset using 1(One) Meter Straight Edge and measured the Horizontal Offset on the web using a Bridge Cam gauge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 12AE (U-Rib to U-Rib)

This QA Inspector performed Dimension Control Inspection for measuring offset for the U-Rib to U-Rib from Cross Beam side towards Bike Path side at a total of 37 locations on Segment 12AE between Panel Points (PP) 112 to PP 112.5 at OBG Trial Assembly:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Note: At location 13th and 27th location there is no U-Rib as per design.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Bike Path at Bay # 1

This QA Inspector performed Dimension Control Inspection on the Traveler Rails.

The following check was performed on the Traveler Rail 20TR2-001.

Measured the overall length.

Measured the overall sweep.

Measured the thickness at typical section-Fixed End.

Measured the thickness at typical section-Sliding End.

Measured the Flange width at typical section-Fixed End.

Measured the Flange width at typical section-Sliding End.

Measured the depth at typical section-Fixed End.

Measured the depth at typical section-Sliding End.

Measure the Flange curl at typical section-Fixed End.

Measure the Flange curl at typical section-Sliding End.

The QA Inspector measured the Mis-Alignment using 600mm Straight Edge, Carpenter Square and Measuring Tape.

Bike Path at Bay # 1

This QA Inspector performed Dimension Control Inspection on the Traveler Rails.

The following check was performed on the Traveler Rail 20TR2-002.

Measured the overall length.

Measured the overall sweep.

Measured the thickness at typical section-Fixed End.

Measured the thickness at typical section-Sliding End.

Measured the Flange width at typical section-Fixed End.

Measured the Flange width at typical section-Sliding End.

Measured the depth at typical section-Fixed End.

Measured the depth at typical section-Sliding End.

Measure the Flange curl at typical section-Fixed End.

Measure the Flange curl at typical section-Sliding End.

The QA Inspector measured the Mis-Alignment using 600mm Straight Edge, Carpenter Square and Measuring Tape.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer